



Dart Aerospace Ltd.
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D3219-1
Job Sheet 169057

Part No: D3219-1

Job Qty: 30 ea

Part Name: Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/30/17

Job Tracking No:

Due Date: 12/5/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP A 04.04.19 New issue KJ/JLM ESR B 06.05.25 Waterjet EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		12/4/17	0.00	0.00	Start Up Waterjet		
100	Waterjet	30 pcs		12/5/17	0.01	0.62	Waterjet1		
120	QC	30 pcs		12/5/17	0.00	0.00	QC8		
150	Packaging	30 pcs		12/5/17	0.00	0.00	Packaging3		
160	QC21-SA	30 Ea		12/5/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3219

Descriptions: 150 - *** STOCK IN STEP CELL***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.125	3	59	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plate	0.316inches + 0.006 - 0.001	0.322 0.315		
2	Plate	2.293inches ± 0.005	2.298 2.288		
3	Plate	0.375inches ± 0.010	0.385 0.365		
4	Plate	0.125inches ± 0.010	0.135 0.115		
5	Plate	0.125inches ± 0.010	0.135 0.115		

Plex 11/30/17 8:29 AM dart.poulin.mario

QA Closed: _____ Date: _____		DQA: _____ Date: _____	
WORK ORDER NON-CONFORMANCE / UPDATE			
		☐ Work Order update only	
AGAINST DEPARTMENT/PROCESS		DISPOSITION	
☐ Engineering ☐ Quality ☐ Other	☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier	☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab	☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite
Date : _____ Step #: _____		QTY Effective : _____	
Work Order: _____ Part No. _____ NCR No. _____		Description Work Order: _____	
Mfg Date: 12/01/17 Job No: 169057		Change No: Operation: Start up Operation Revision: PART NO: D3219-1	
Completed By: _____ Lead hand / Supervisor Approval Verification: _____ QC / QA Coordinator Approval: _____		 Plate	
 S016525			
Contamination Counter-sink Cut Too Short Instructions Incomplete/Unclear Misaligned/off center		Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter	
Out of Sequence Off-set Mis-labeled Fit/Function		Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence	
OTHER :			
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified			
No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due			

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